

Work Order ID 68225

Friday, April 08, 2011 2:36:08 PM



Page 1

Item ID: D4170-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 4/8/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/11/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4170

B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per Folio FA962

41

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

41

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Work Order ID 68225

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Page 2

Item ID: D4170-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 4/8/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/11/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

125

0.00



Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

41 0 BE 4/8/15

130

0.00



Packaging

Identify as per dwg & Stock Location: LG

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

41 18 BE 4/8/15

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/4/18 MF 11-04-15

Picklist Print

Friday, April 08, 2011 2:36:06 PM

Page 1

Work Order ID: 68225

Parent Item: D4170-1

Parent Item Name: Bushing



Start Date: 4/8/2011

Required Date: 4/11/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD IPP
Rev:A 10.11.02 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.375W.058

Purchased

No

100

f

120.0000

0.2666

11.22526



11.4.11

6061-T6 RD Tube .375 x.058W

Location

Loc Qty

Loc Code

MAT014

120

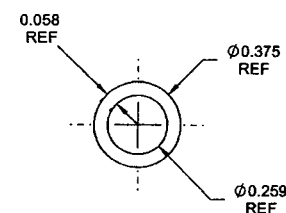
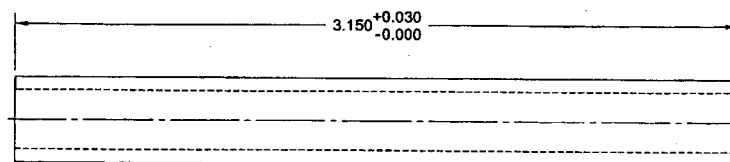
115901

12

115920

108

11.162



D4170-1 SPACER

RELEASED
2010-11-01

W/O 68225

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, Ø3/8 OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.375W.058
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

B	ADD -3 (SHEET 2)	CP	10.10.25
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D4170	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SPACER	NTS
DATE	10.10.25	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

D

D

C

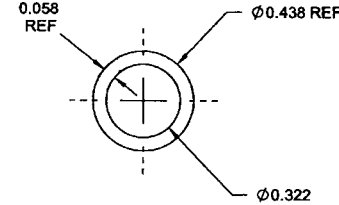
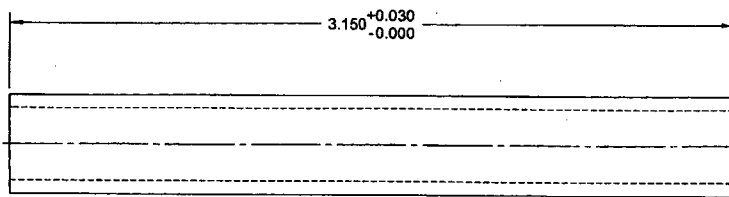
C

B

B

A

A



D4170-3 SPACER

NOTES:

- 1) MATERIAL: 6061-T6 ROUND BAR, Ø7/16 OD
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221
REF DART SPEC. M6061T6R0.438
- OR
6061-T6 OR 6061-T62 TUBING, Ø7/16 OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.438W.058
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

68225


RELEASE
2010-11-01
ND

DESIGN		SC	DART AEROSPACE USA, INC.	
DRAWN		<i>JP</i>	PORT HADLOCK, WA	
CHECKED		<i>JP</i>	DRAWING NO.	REV. B
MFG. APPR.		<i>JP</i>	D4170	SHEET 2 OF 2
APPROVED		<i>JP</i>	TITLE	SCALE
DE APPR.		<i>JP</i>	SPACER	NTS
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8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order:	<i>(Signature)</i>
Description: Spacer		Part Number:	D4170-1
Inspection Dwg: D4170	Rev: B		Page 1 of 1

[illegible]

Rev	Date	Change	Revised by	Approved
A	10.10.08	New Issue	KJ	
B	11.01.28	Dwg Rev updated	KJ	